

5127
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DART AEROSPACE LTD

Work Order: 23570

Description: Outer Saddle

Part Number: D2919-1

Dwg: D2919 Rev. A1

Qty: 1

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	AK	05.06.23	1
2	MV	Cut blanks: 2.500" x 8.250" x 7.950" grain along 7.950" Material: 6061-T6/T651 (QQ-A-250/11) (D6102-010) Identify as D2919-1	ML	05/06/27	1
3	MV	Program batch number	ML	05/06/27	1
4	MV	Machine Step No 1 as per Folio FA533 and visually inspect as per Dwg D2919 & attached Dimension Sheet	ML	05/06/27	1
5	MV	Machine Step No 2 as per Folio FA533 and visually inspect as per Dwg D2919 & attached Dimension Sheet	ML	05/06/27	1
6	MV	Machine Step No 3 as per Folio FA533 and visually inspect as per Dwg D2919 & attached Dimension Sheet	ML	05/06/27	1
7	MV	Machine Keyway and inspect per Dwg D2919 & attached dimension sheet	FE	05.06.29	1
8	MV	Deburr	FE	05.06.29	1
9	QC2	Inspect parts as they come off the CNC machine	FE	05.06.29	1
10	QC8	Second inspection	UP	05.06.30	1
11	FP	Acid etch and Alodine as per QSI 005 4.1	ML	05 07 04	1
12	FP	Powder Coat Gloss White (4.3.5.1) as per Dart QSI 005 4.3	ML	05 07 04	1
13	QC3	Inspect Powder Coat	CL	05/07/05	1
14	ST	Identify and Stock	CL	05/07/05	1
15	AC	Cost / part 538.87	SAC	05.07.06	1
16	DC	Close W/O 538.87 Inspect Level 21	AK	05.07.18	1

Rev	Date	Change	Revised By	Approved
A	05.06.23	New Issue	KJ/JLM	

RELEASED
05.06.23

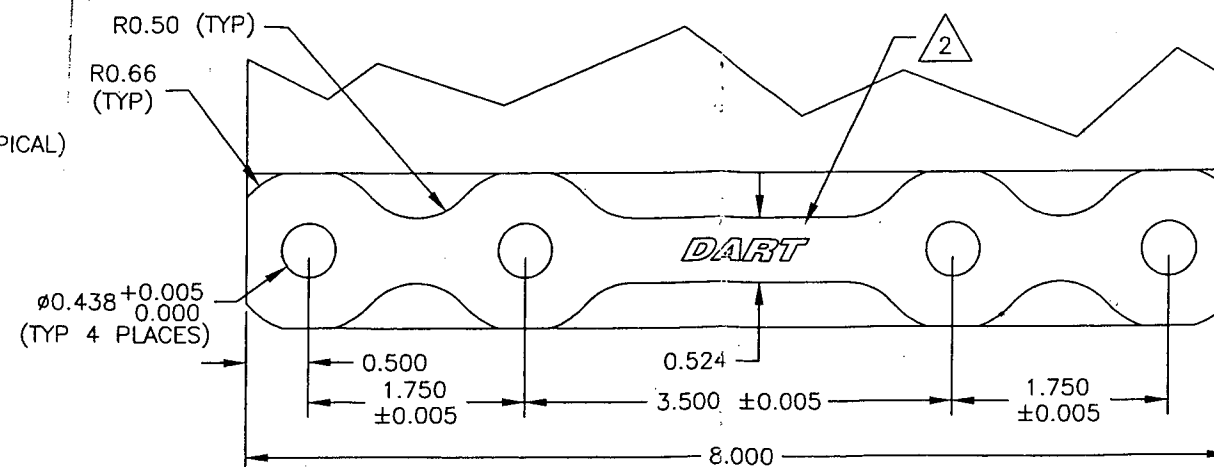
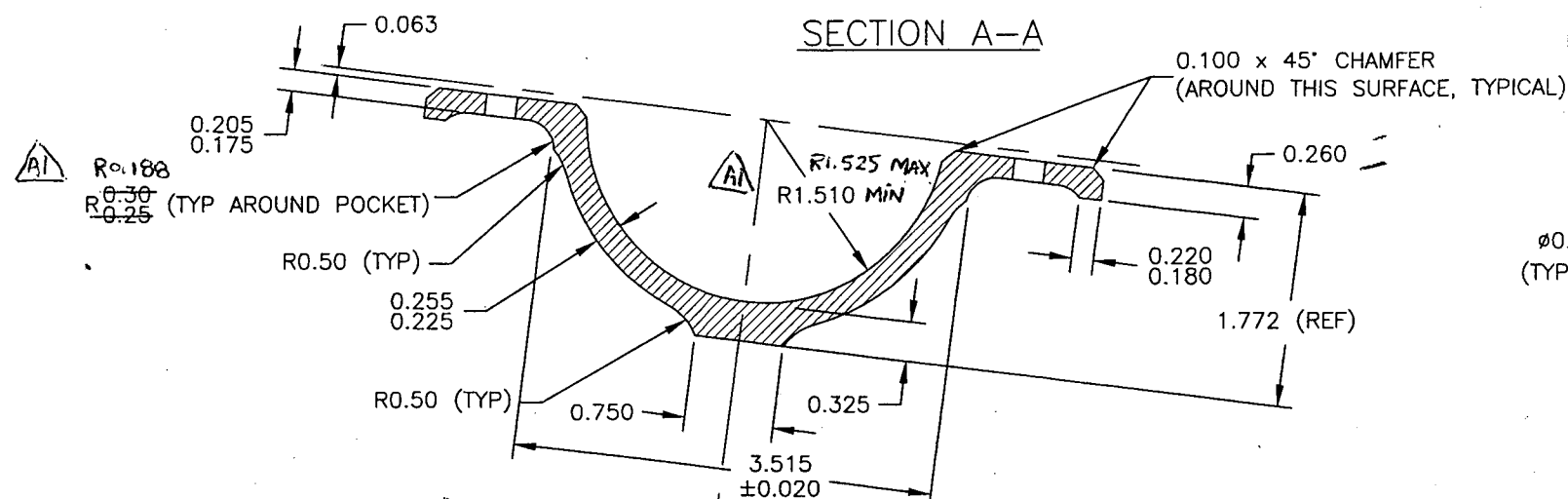
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

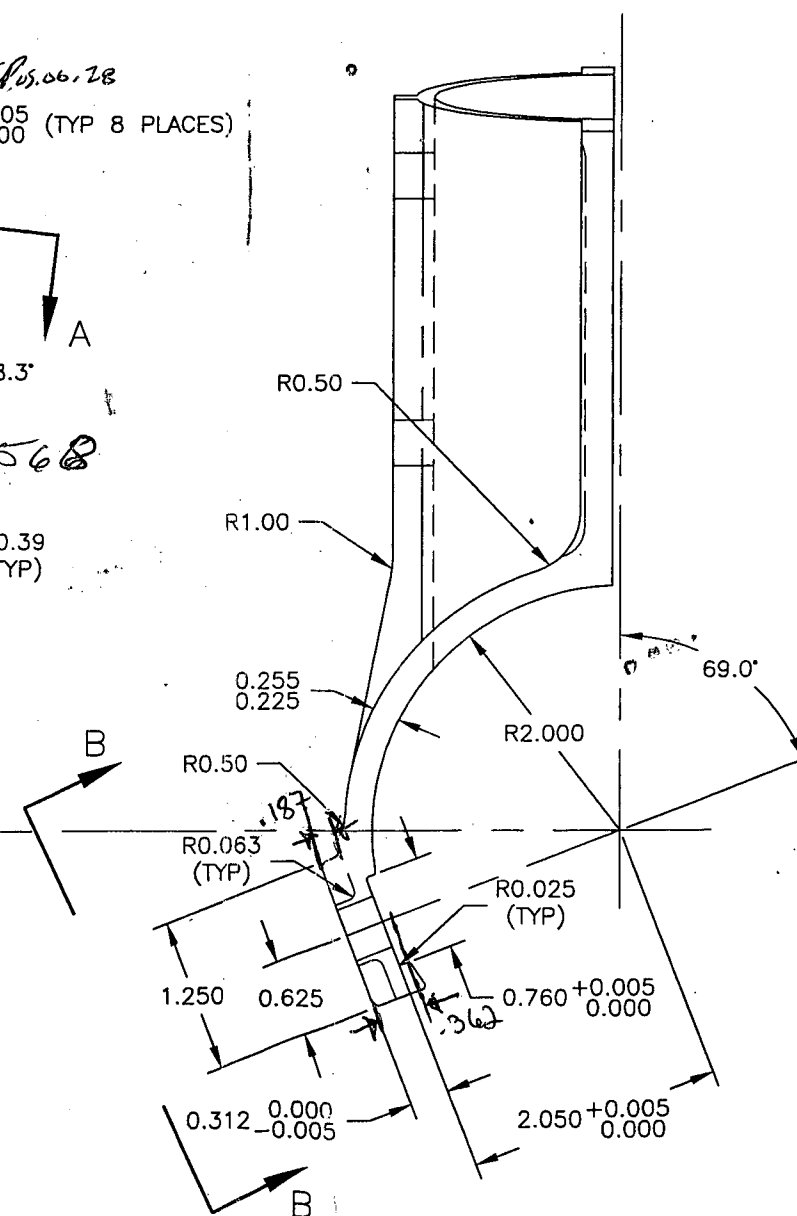
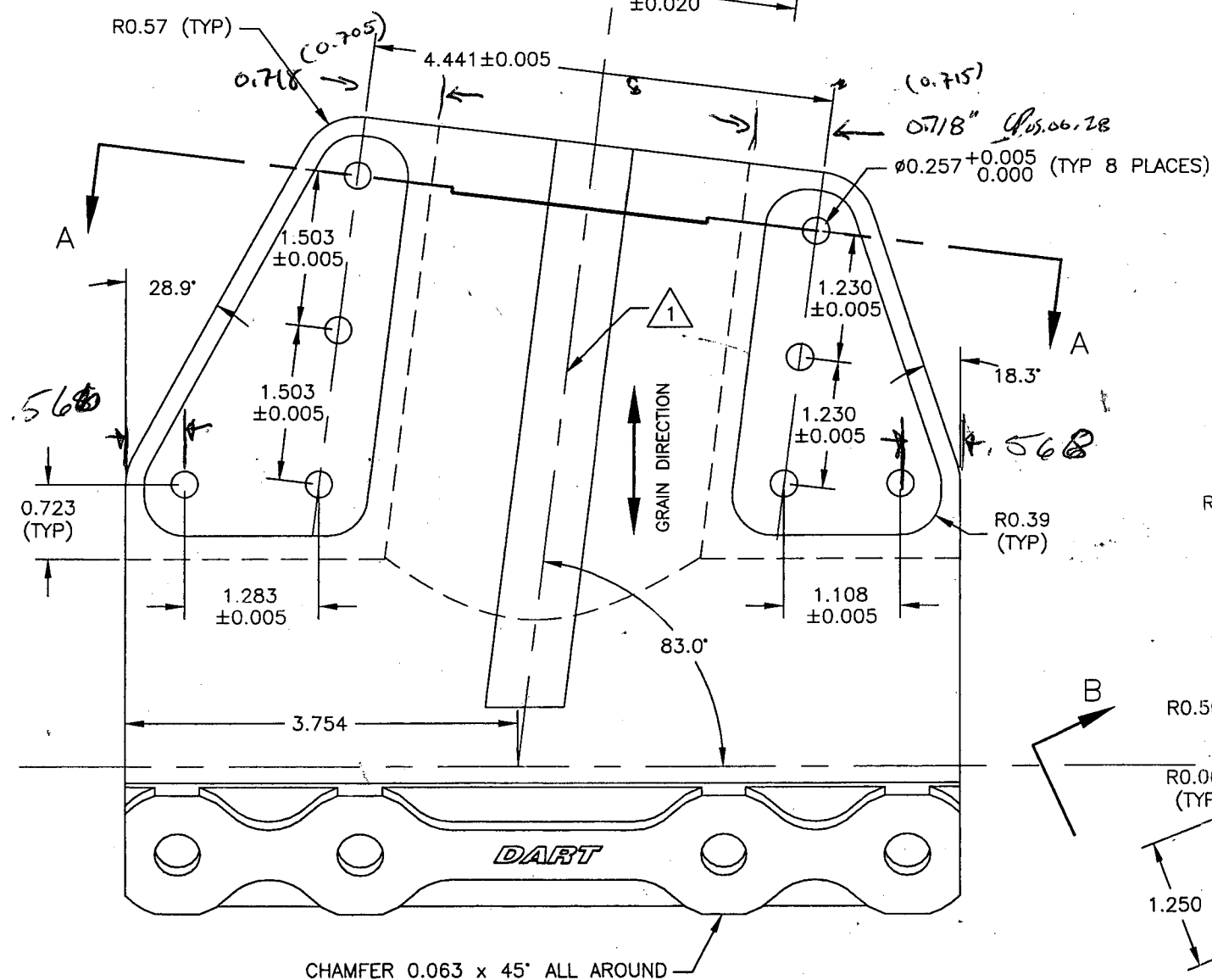
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



VIEW B-B



SHOP CO
RETURN
ENGINEER

UNCONTROLLED
SUBJECT TO A

D2919-1 LH SADDLE (SHOWN) WITHOUT
D2919-2 RH SADDLE (OPPOSITE)

MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-250/11)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125


RELEASE
04.06.22

AI	04.08.13	CHANGE RAD & TOLERANCE
A	04.06.22	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO. D2919
DATE		TITLE OUTER SADDLE
04.06.22		

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 16, 2005
08:04 am

Work Order No : 0023570
Project Name : D2919-1
Project For : WK527
Work Order Type : Main
Main WO Number :
House Part Number : D2919-1
Description : Saddle LH
Manufactured : No
Amount Req'd : 
Amount Done : 0
Start Date : 06-14-05
Est Finish Date : 07-04-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order:	23570
Description:		Part Number:	D2919-1
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R.50	± 0.03	R.50	✓			
R 2.000	± 0.01	1.993	✓	NA		OK B
R.025	"	R.025	✓			
0.760	$+0.005$ -0.000	0.764	✓			
0.362	± 0.01	0.366	✓			
2.050	$+0.005$ -0.000					Can't measure B
0.312	$+0.000$ -0.005	0.312	✓			
0.625	± 0.01	0.624	✓			
1.250	"	1.248				
R 0.063	"	R.063	✓			
0.255/0.225	N/A	0.248	✓			
<hr/>						
φ.438	$+0.005$ -0.000	φ.440	✓			
0.500	± 0.01	0.500	✓			
1.750	± 0.005	1.750	✓			
3.500	"	3.501	✓			
1.750	"	1.751	✓			
0.524	± 0.01	0.521	✓			
8.000	"	8.002	✓			

Measured by: <i>B</i>	Audited by: <i>CP</i>	Prototype Approval: <i>CP</i> 05.06.30
Date: 05.06.28	Date: 05.06.30	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

BAK AEROSPACE LTD

Work Order:

23570

Description:

Part Number:

D2919-1

Inspection Date:

Rev:

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FIRST ARTICLE INSPECTION CHECKLIST

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First Article

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Prototype

Org. Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.205 / 0.175	N/A	0.195	✓			
1.510 / 1.525	N/A	1.511	✓			
0.100" x 45°	±0.01	0.103 x 45°	✓			
0.260	"	0.258	✓			
0.220 / 0.180	N/A	0.215	✓			
1.772	±0.01	1.775	✓			
0.325	"	0.328	✓			
3.515	±0.020	3.530	✓			
0.750	±0.01	0.760	✓			
0.255 / 0.225	N/A	0.250	✓			
R 0.188	±0.01	R.188	✓			
<hr/>						
4.441	±0.005	4.441	✓			
Ø.257	±0.005 -0.000	Ø.258	✓			
1.230	±0.005	1.231	✓			
1.230	"	1.229	✓			
1.108	"	1.109	✓			
83°	±0.5°	83°	✓			
1.283	±0.005	1.282	✓			
0.723	±0.01	0.728	✓			
1.503	±0.005	1.503	✓			
1.503	"	1.502	✓			
<hr/>						

Measured by:

EE

Audited by:

AP

Prototype Approval:

AP

Date:

05.06.28

Date:

05.06.30

Date:

05.06.30

Rev

Date

Change

New Issue

Revised by

KJ/JLM

Approved